

IN THE SPECIFICATION

Please amend the first two paragraphs appearing on page 1 of the application to read as follows:

-- The invention pertains to a method for deep-rolling radii or fillets at the transitions between the bearing journals and the adjacent flange of a bearing point of a crankshaft with the aid of deep-rolling cylinders that are pressed into the radius or the fillet of the transitions with a deep-rolling force while the crankshaft is ~~turned~~ rotated until a predetermined roll-down depth is reached.

Deep-rolling tools for deep-rolling fillets on the bearing journals of crankshafts are known, for example, from US 6,393,885 B1. Internal compressive stresses are produced in the metal of the fillets of the crankshaft with the aid of known deep-rolling methods, wherein these compressive stresses may extend, for example, to a depth of 4 mm. The actual value of the rounding radii of deep-rolling cylinders should, as is known, be determined in such a way that they lie within the manufacturing tolerances for the fillets on the crankshaft. Adequate results are achieved if the rounding radius of the deep-rolling cylinder approximately conforms to the radius of the fillet. The deep-rolling force exerted by the deep-rolling cylinders can be increased or decreased while the crankshaft is ~~turned~~ rotated in order to produce patterns of concentrated internal compressive stresses in the metal of the fillets that represent the regions of a crankshaft which are subjected to the highest loads. The intensity of the deep-rolling force as well as the number of fillet rolling passes can, as is known, be predetermined in order to achieve an optimal fatigue strength. It is also advantageous to increase the actual width of the bearing journals of

crankshafts. However, in down depth to be additionally achieved with the second deep rolling cylinder is approximately 0.05 mm. --